

Date: Wednesday, 2/20/2008 4:20:04 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-UTILITY BASKET RH
 Job Number : 37516
 Estimate Number : 13190
 P.O. Number :
 Part Number : D205541046
 This Issue : 2/20/2008 S.O. No. : Drawing Number : IIN D205-541 REV G
 Prsht Rev. : NC Project Number :
 First Issue : 11 Type : LARGE FAB ASSY Drawing Revision : G
 Previous Run : 37515 Material :
 Due Date : 3/14/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A new issue 08-02-15 verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD205-541-046 CHG001

2.0 D3712042 LOW PROFILE BASKET BASE ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 LOW PROFILE BASKET BASE ASSEMBLY 37525

3.0 D3713042 LID ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 LID ASSEMBLY 37528

4.0 D2258300 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Placard
 Batch: 1228072

5.0 D2332041 Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Lid Prop Assembly 6.69"
 Batch: 135718

6.0 D2530 Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Handle Weldment
 Batch: 136657

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37516

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 136397

SC

8.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 136853

SC

9.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 121139

SC

10.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104603

11.0

AN417A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

M105653

PTO
→

12.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104937

SC

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104547

8/3/11 SC (B)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.03.12	11.0	ANY-17A should be ANY-20A. (IIN will be updated)	SA	08/03/12	3	LE 08.03.12	08/03/14
08/03/12	11						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37516

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104625 (2x)

M107242 (2x)

SP

15.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M106277

PT 0

SP

16.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M106654

SP

17.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M107442

SP

18.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M106242

SP

19.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

Batch: M105938

SP

20.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

8/3/11

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/03/12	ISA	2 AN960JD416 L Washer TA 106785 take away qty (2) AN960JD416 (instead of 2 AN960JD416)	SS	08/03/12	2	LE 08.03.12		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37516

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: 17071

SP

22.0

D37231

FWD PLATE



~~B37530~~

~~B37530~~



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

FWD PLATE

B 37530

SB

23.0

D37571

Blanking Plate



OPB

~~B37473~~



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Blanking Plate

B 37473

SB

24.0

AN311A

Bolt



LE 08-03-12

M17566



SP

Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

25.0

AN960JD10

Washer



M106552



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

8/3/11 SP

(1x)

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



ASS 0803/14

ENGINEERING



FF 08-03-13

(1)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg.

APPROVAL

P70

~~0803/14~~

27.0

QC5

INSPECT WORK TO CURRENT STEP



7



Comment: INSPECT WORK TO CURRENT STEP

0803/14 (40)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-03-12	26.0	- Scuff surface of label plate with 320, or Redscotch brite. - Wash surface with 4105's wash 'n' wipe. & Ensure surface is clean - Apply label - F.P.) Apply 2 coats of Armor shield over the label & label plate surface Armor shield: chip guard M <u>106053</u>	FF	08-03-13		AS 08-03-12	08-03-12	
08/03/12	24	AN3-10A Should be AN3-11A M <u>14820</u>	JB	08/03/12	6	VE 08-03-12	08-03-12	
08/03/12	25A	2 AN960JD 8 M <u>106918</u>	JB	08/03/12	2		08-03-13	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:20:04 PM

User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37516

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

D21991

Struts, 19"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Struts, 19"

Batch:

B28996

AS

08/03/14 (X)

30.0

D219923

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Strut

Batch:

29387

AS

08/03/14 (X)

31.0

D219925

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Strut

Batch:

37537

AS

08/03/14 (X)

32.0

D2498

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Mounting Bracket

Batch:

27683

AS

08/03/14 (X)

33.0

D2499

Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Mounting Bracket

Batch:

B27501

AS

08/03/14 (X)

34.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bushing

Batch:

B29138

AS

08/03/14

(X)

35.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Mounting Lug

Batch:

B28522

AS

08/03/14

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37516

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M102140

AS 08/03/14 (X)

37.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M105143

AS 08/03/14 (X)

38.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: M106993

AS 08/03/14 (X)

39.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M105653

AS 08/03/14 (X)

40.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M106785

AS 08/03/14 (X)

41.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104936

AS 08/03/14 (X)

42.0

AN960JD416

Washer



Comment: Qty.: 27.0000 Each(s)/Unit Total : 27.0000 Each(s)

Washer

Batch: M106277

AS 08/03/14 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 29/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 37516

Part Number: D205541046

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch: M106654

AS 08/03/14 (X)

44.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch: M105938

AS 08/03/14 (X)

45.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M106277

AS 08/03/14 (X)

46.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/03/15 (X)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-044

Location: DDAF

PPP Rev: DDAF

AS 8/8/17 (1)

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/03/17

Job Completion



AS 08/03/17

POSITIVE RECALL

EFFECTIVE 08/02/21 AUTH AA

RELEASED 08/03/17 DATE AA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

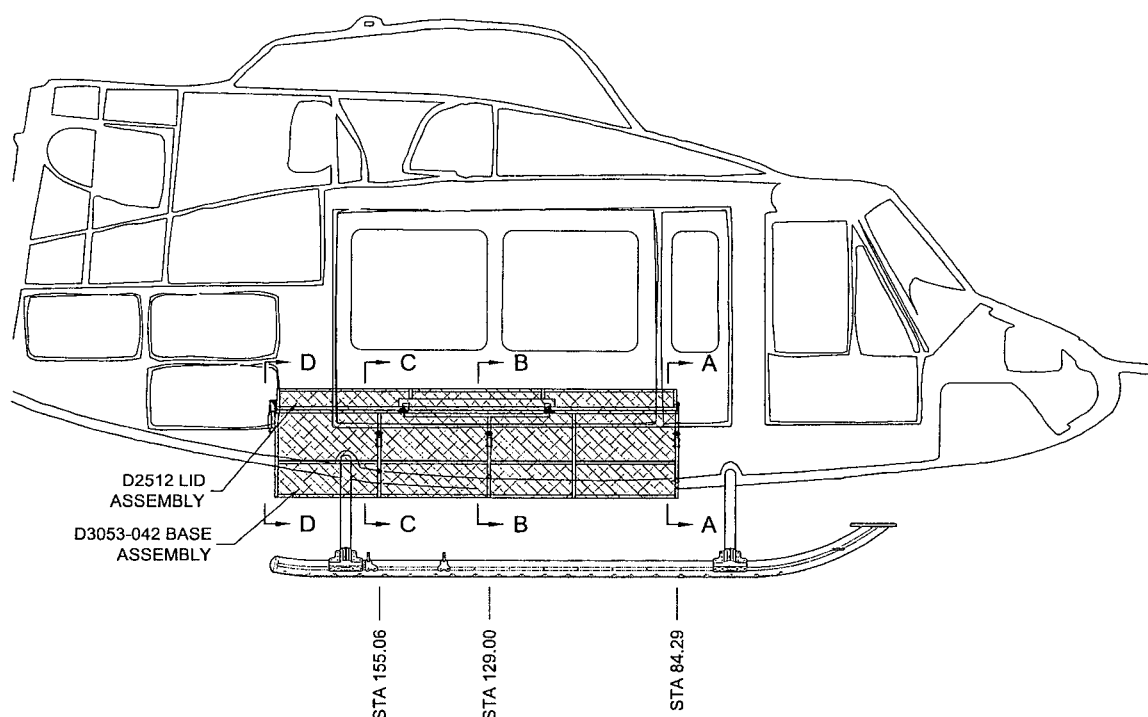


Figure 1a - D205-541-044 Heli-Utility-Basket™ - Side View Shown
(D205-541-043 Opposite)

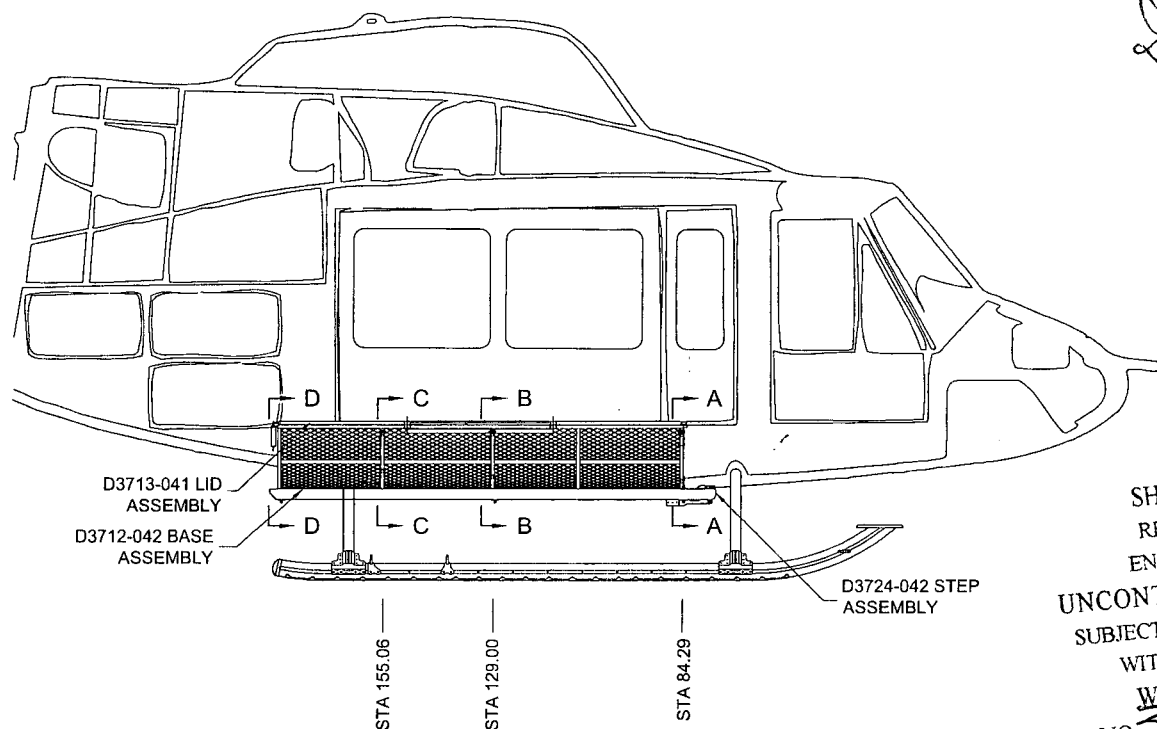


Figure 1b - D205-541-046 Heli-Utility-Basket™ - Side View Shown
(D205-541-045 Opposite)

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Revision: **G**

Date: 08.02.04

PRELIMINARY ISSUE
435 02.21.08

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WORK ORDER
NO 37516

- 3.2.4 Reposition the step assembly with the basket and install as shown in Figure 12. Torque the #10 fasteners to 15-25 in-lbs (N-m).

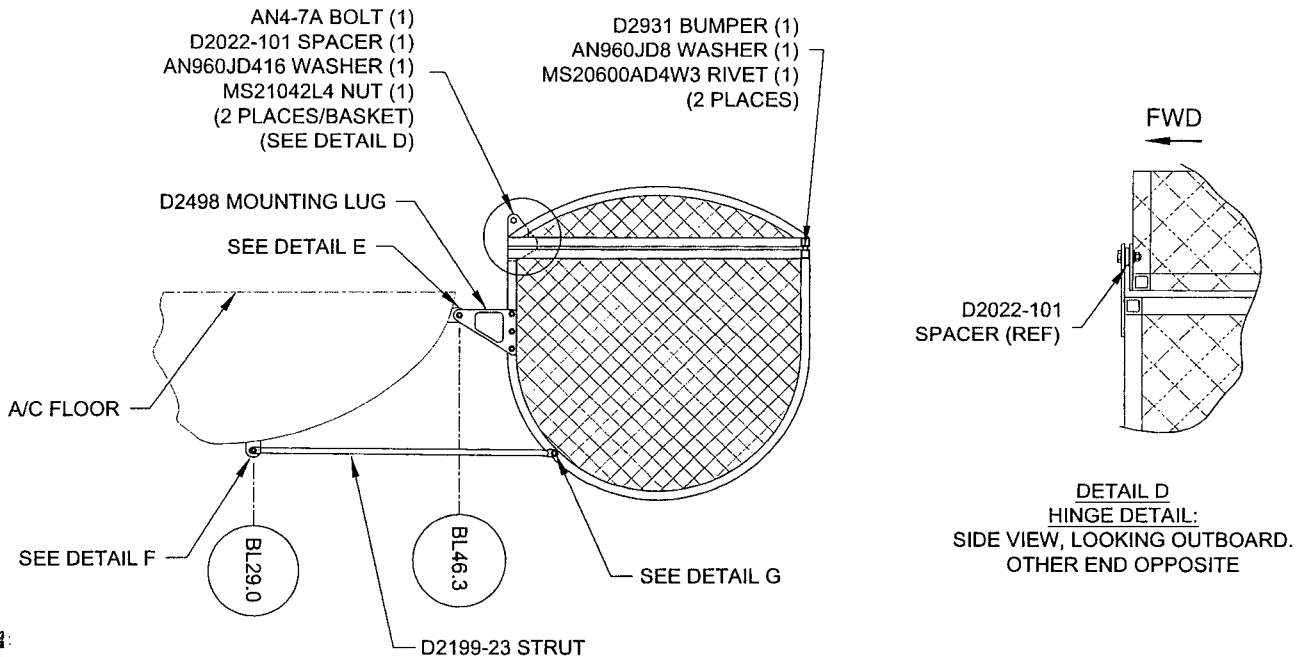


Figure 2a - Section A-A Looking Fwd at STA 84.29
(D205-541-044 Shown; D205-541-043 Opposite)

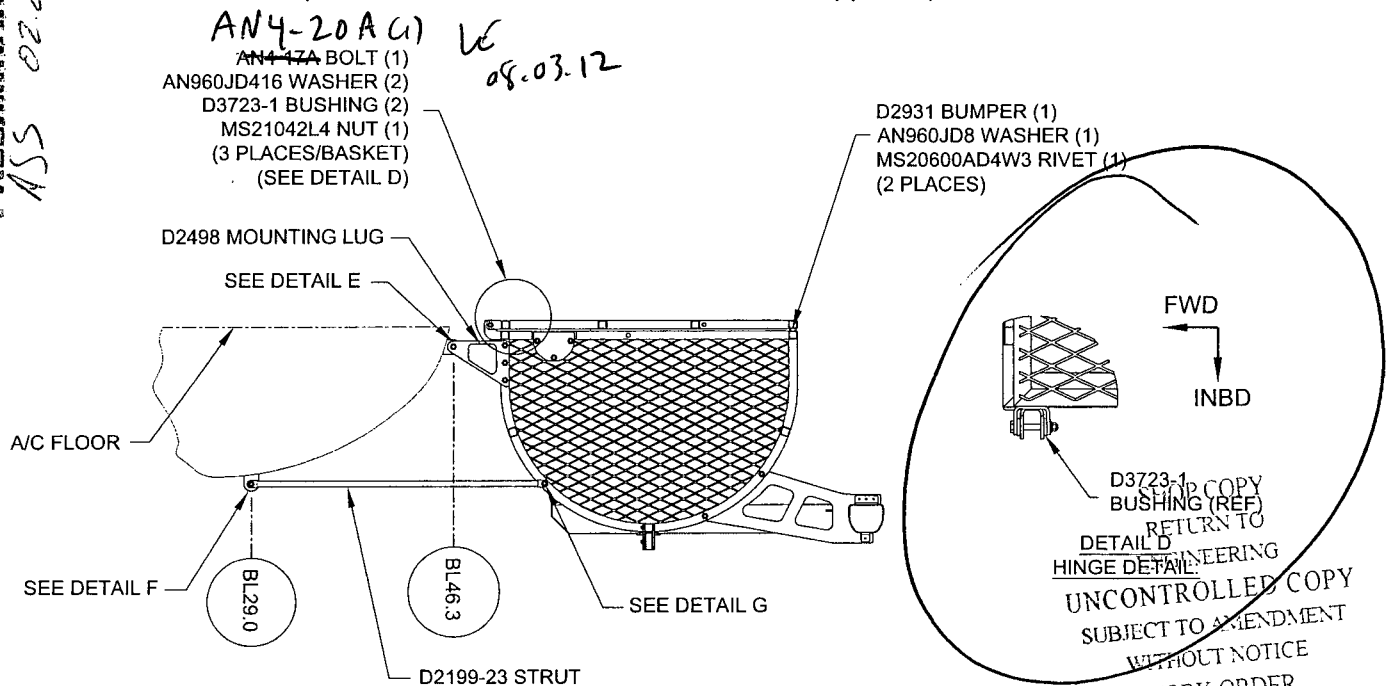


Figure 2B - Section A-A Looking Fwd at STA 84.29
(D205-541-046 Shown; D205-541-045 Opposite)

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Revision: **G**
Date: 08.02.04

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ASS 02.12.08

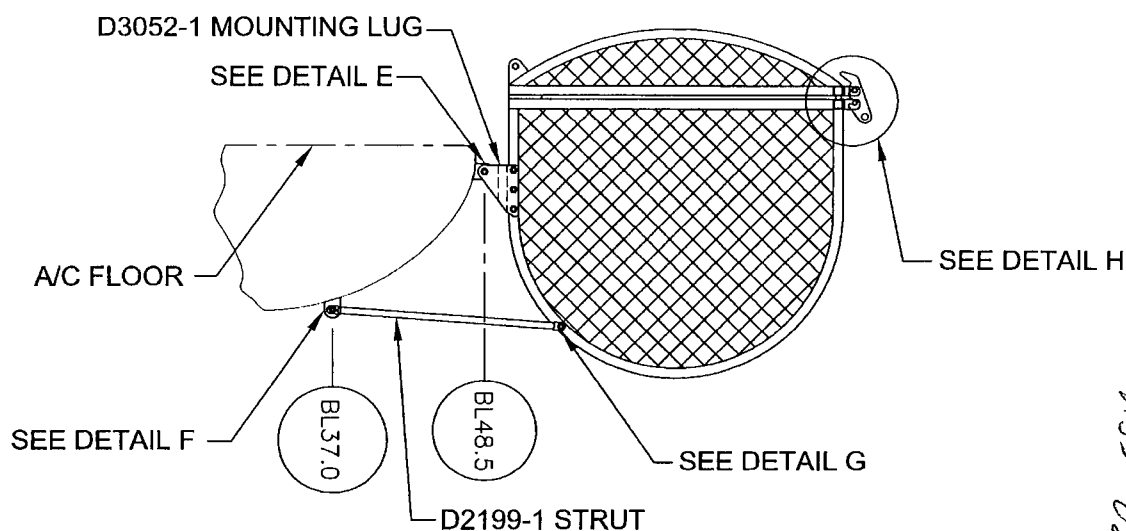


Figure 3a – Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown; D205-541-043 Opposite)

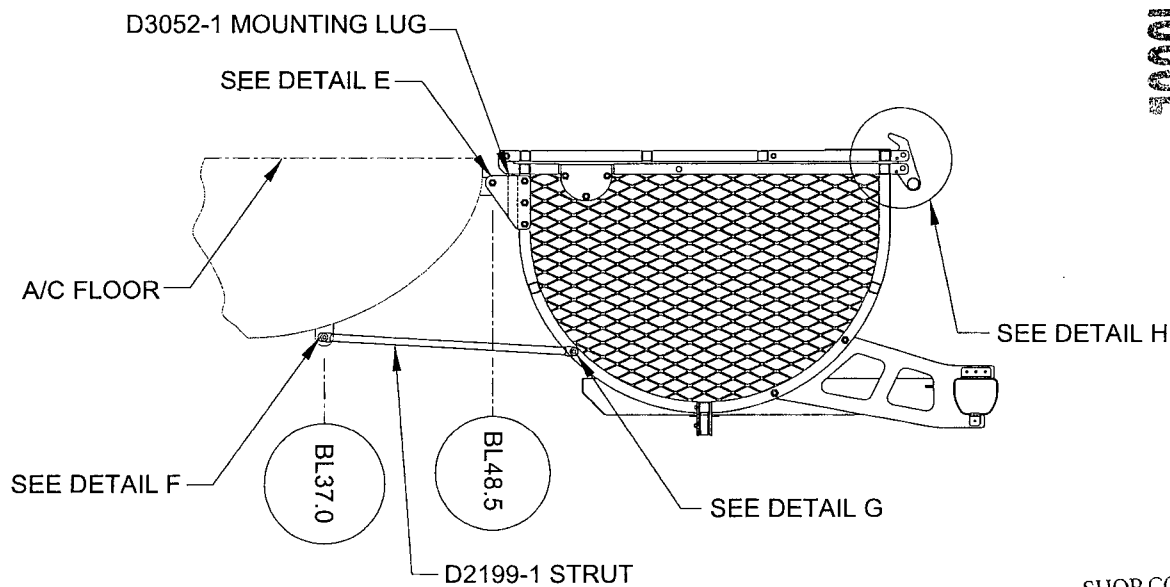


Figure 3b – Section B-B Looking Fwd at STA 129.00
(D205-541-046 Shown; D205-541-045 Opposite)

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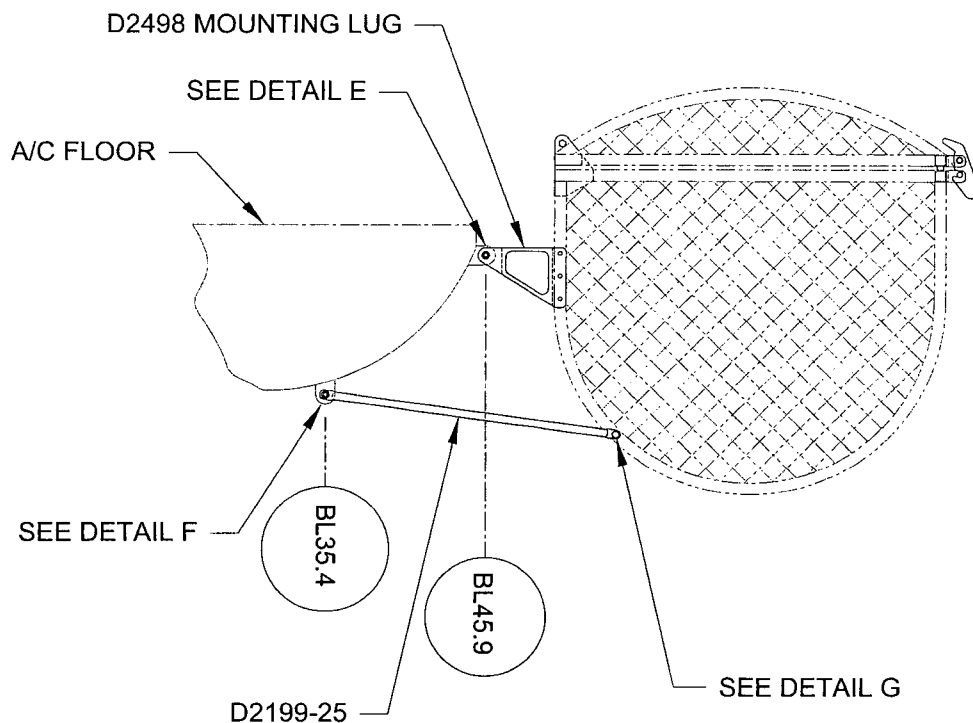


Figure 4a – Section C-C Looking Fwd at STA 155.06

(D205-541-044 Shown; D205-541-043 Opposite)

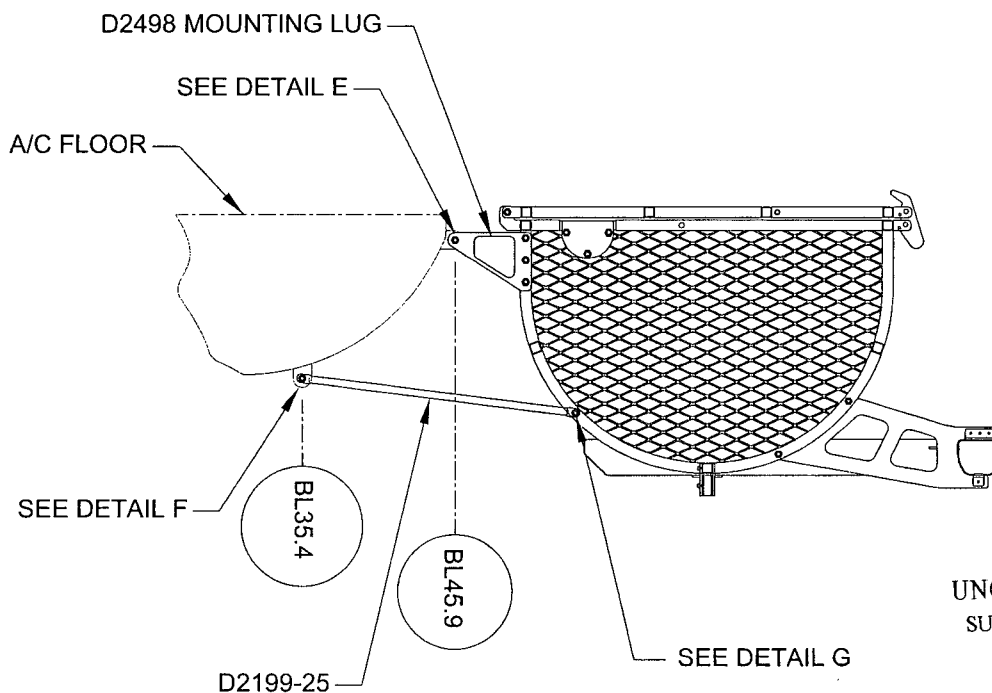


Figure 4b – Section C-C Looking Fwd at STA 155.06

(D205-541-046 Shown; D205-541-045 Opposite)

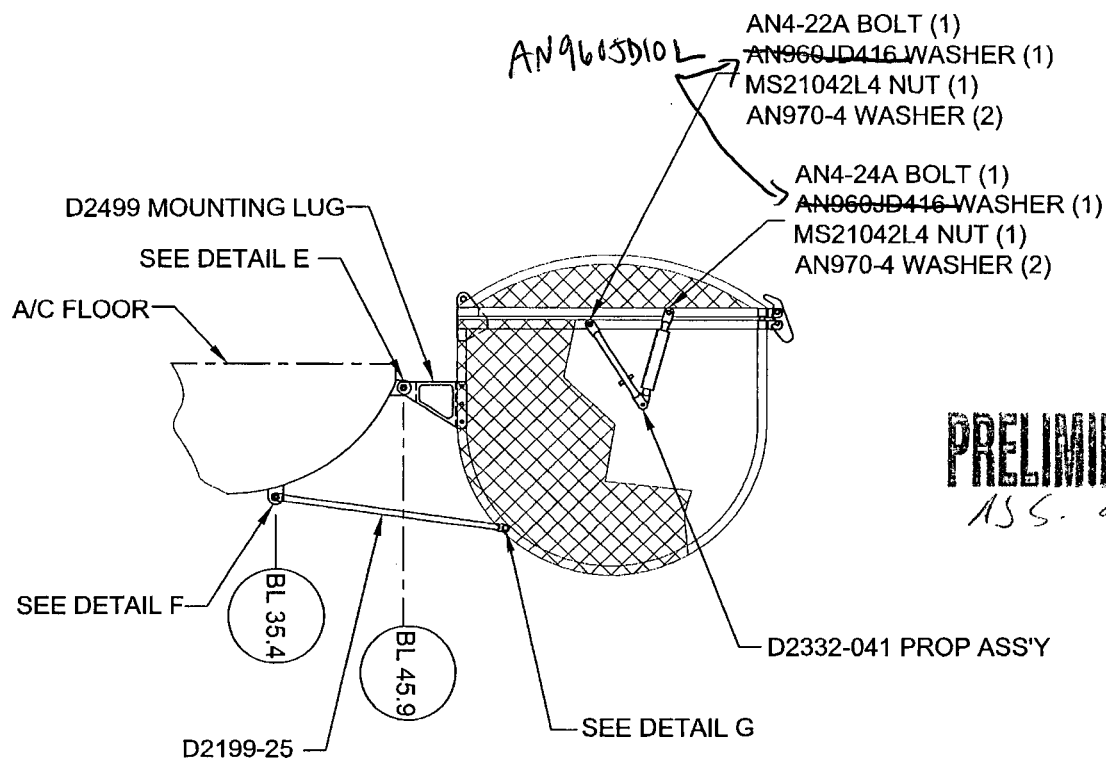
PRELIMINARY ISSUE
155 02.2 1.08

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Revision: **G**

Date: 08.02.04

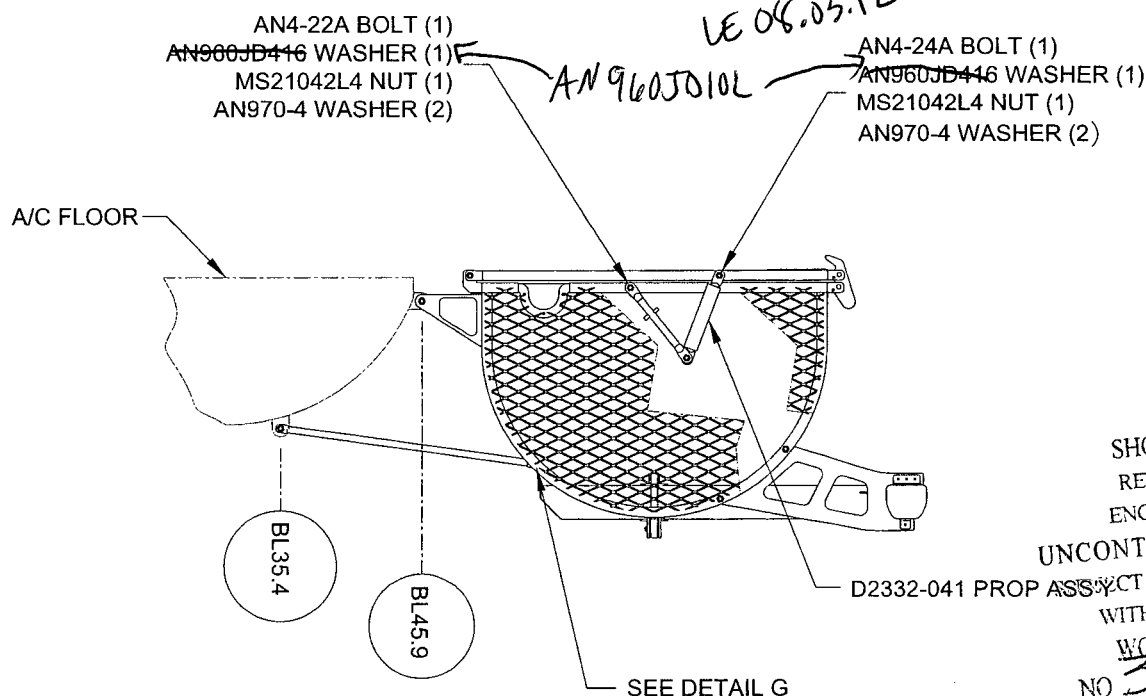


PRELIMINARY ISSUE

155. 02. 21. 08

Figure 4a – Section C-C Looking Fwd at STA 180.08

(D205-541-044 Shown; D205-541-043 Opposite)



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NO 37516

Figure 4b – Section C-C Looking Fwd at STA 180.08

(D205-541-046 Shown; D205-541-045 Opposite)

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Revision: G

Date: 08.02.04

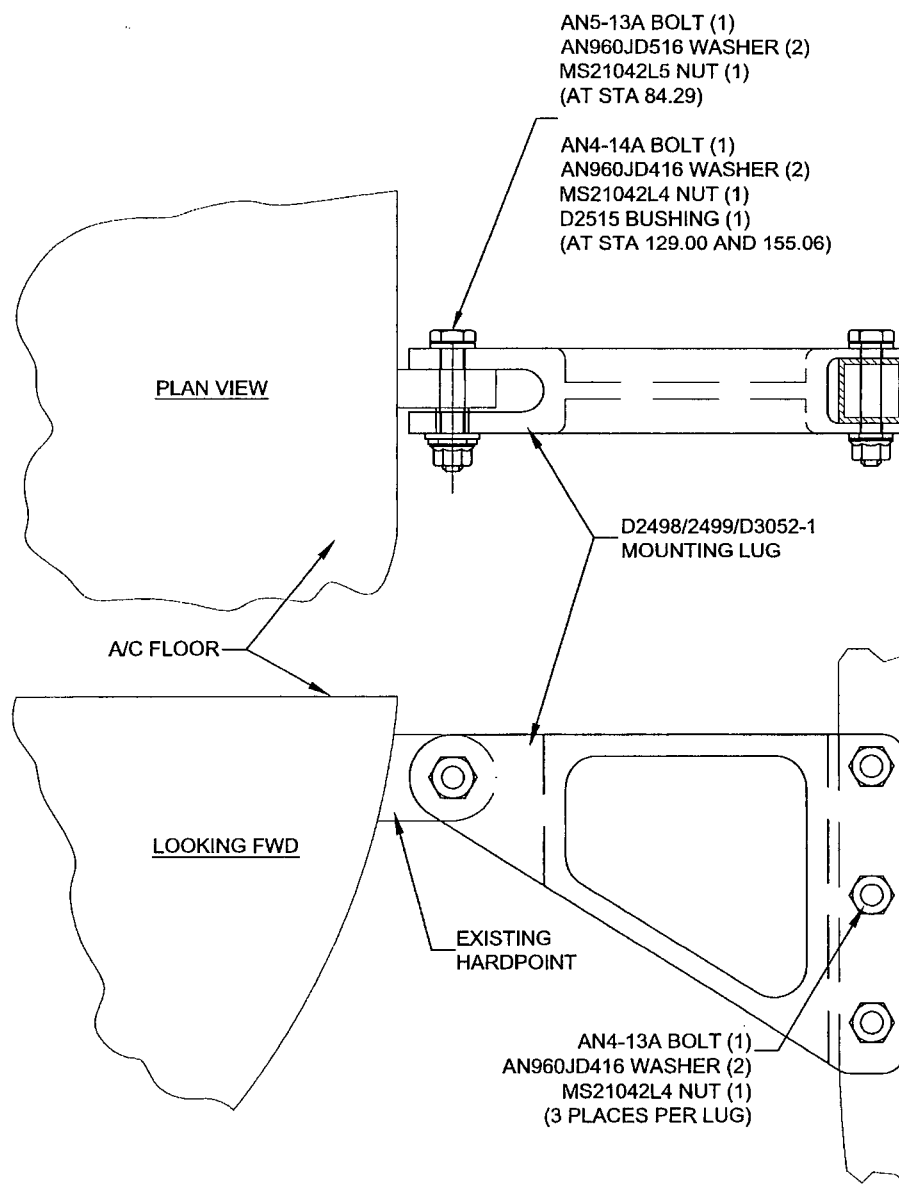


Figure 5 – Detail 'E' Mounting Lug Installation

PRELIMINARY ISSUE

AS S 02.21.09

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Revision: **G**
Date: 08.02.04

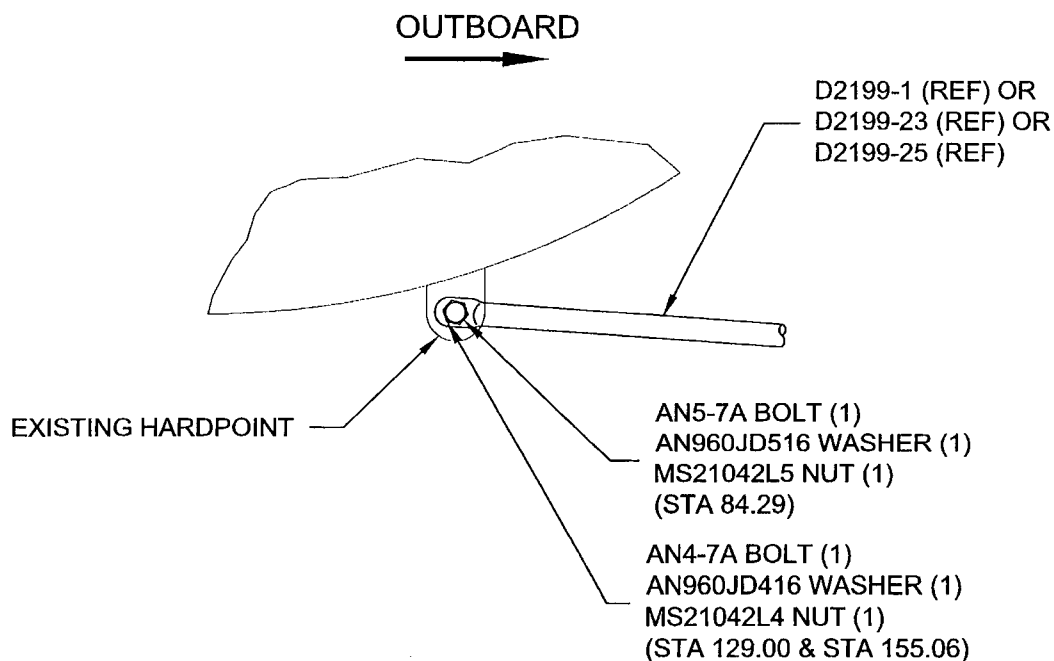


Figure 6 – Detail 'F' Strut to Hardpoint Attachment

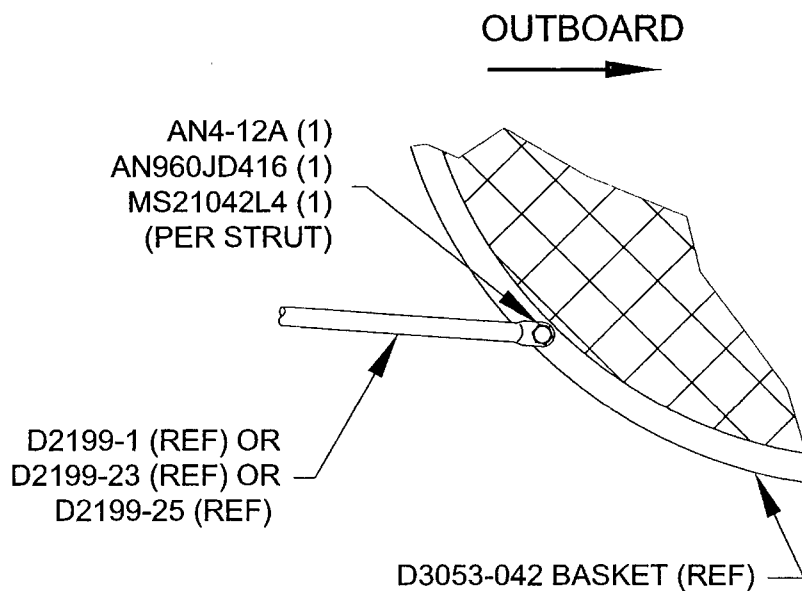


Figure 7 – Detail 'G' Strut to Basket Attachment

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AS 02.21.04

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WORK ORDER NO. 37516

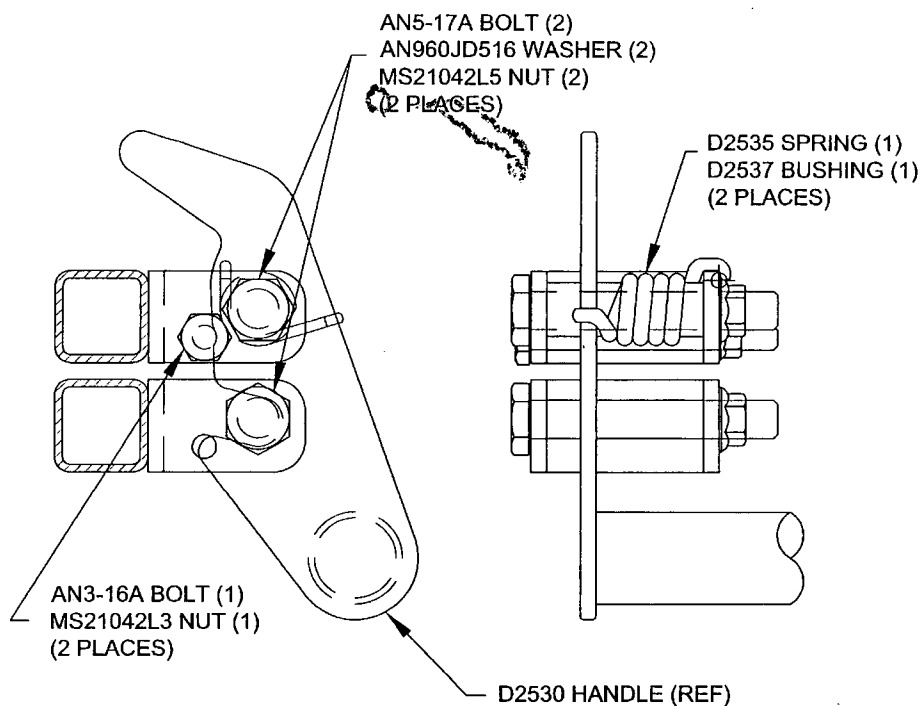


Figure 8 – Detail 'H' Handle Assembly

Figure 9 – Mesh Removal

PRELIMINARY ISSUE

ASS 02.21.08

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WORK ORDER
NO. 37516













Date: Wednesday, 2/20/2008 4:20:04 PM
User: Kim Johnston

Process Sheet

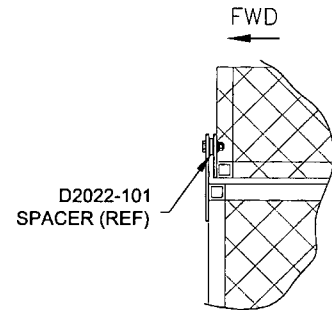
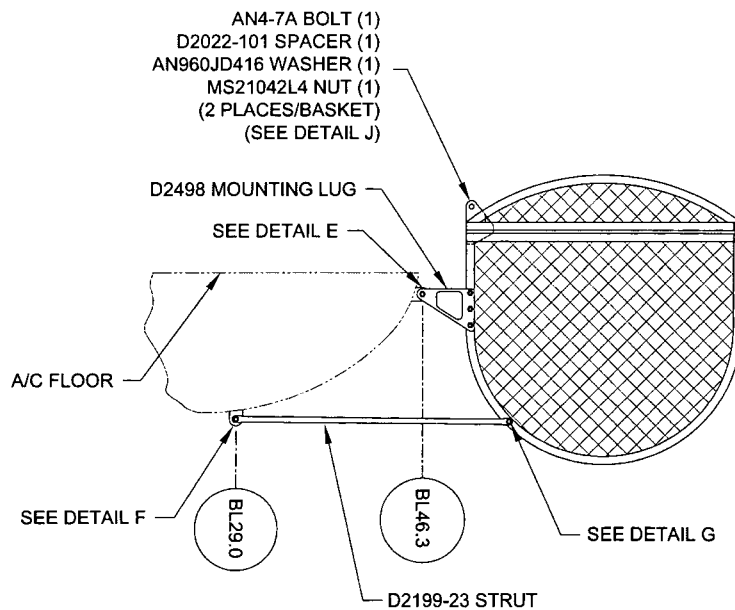
Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-UTILITY BASKET RH
Job Number : 37516
Estimate Number : 13190
P.O. Number :
This Issue : 2/20/2008 S.O. No. :
Prsht Rev. : NC Part Number : D205541046
First Issue : / / Type : LARGE FAB ASSY Drawing Number : IIN D205-541 REV G
Previous Run : 37515 Drawing Revision : G
Written By : Due Date : 3/14/2008 Qty: 1 Um: Each
Checked & Approved By :
Comment : Est Rev:A new issue 08-02-15 verified by:

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		
	Comment: Photocopy bluefile & type labels per PPPD205-541-046 CHG001	
2.0	D3712042	LOW PROFILE BASKET BASE ASSEMBLY
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) LOW PROFILE BASKET BASE ASSEMBLY	
3.0	D3713042	LID ASSEMBLY
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) LID ASSEMBLY	
4.0	D2258300	Placard
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Placard Batch: _____	
5.0	D2332041	Lid Prop Assembly 6.69"
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lid Prop Assembly 6.69" Batch: _____	
6.0	D2530	Handle Weldment
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Handle Weldment Batch: _____	

REFERENCE ONLY



DETAIL J
HINGE DETAIL:
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

Figure 2a - Section A-A Looking Fwd at STA 84.29
(D205-541-044 Shown; D205-541-043 Opposite)

RELEASED
08.03.17
pt

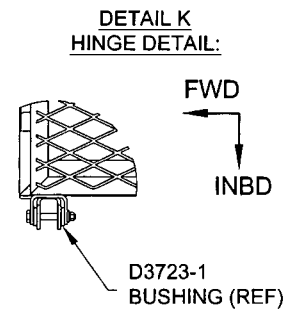
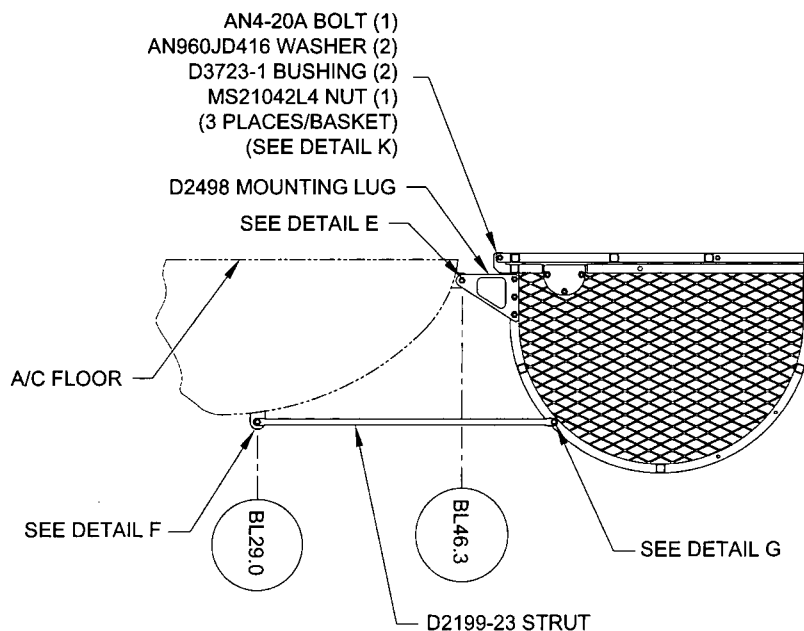


Figure 2b - Section A-A Looking Fwd at STA 84.29
(D205-541-046 Shown; D205-541-045 Opposite)

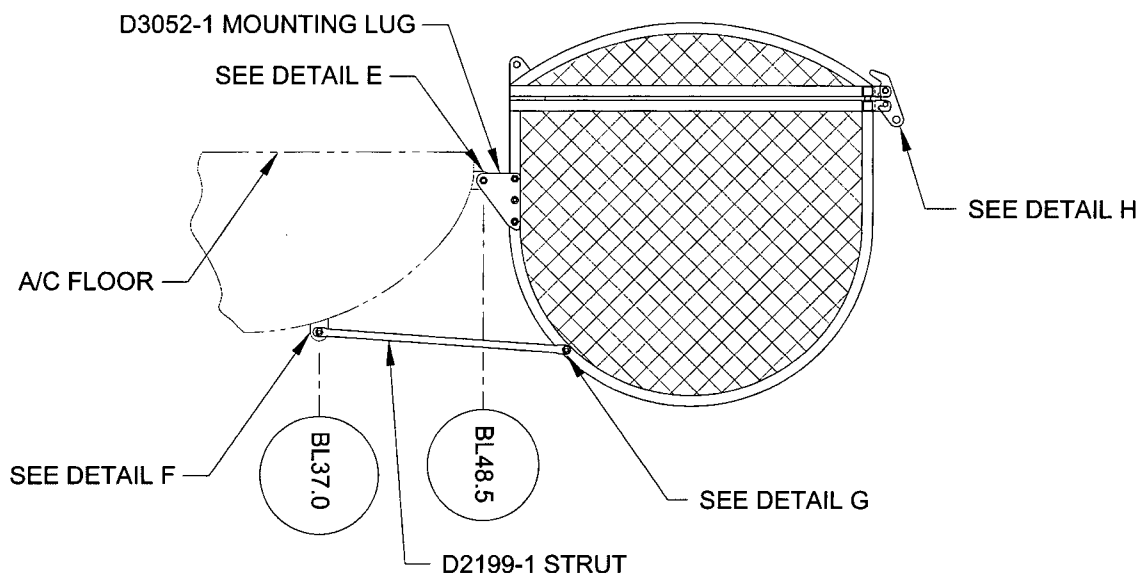


Figure 3a – Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown; D205-541-043 Opposite)

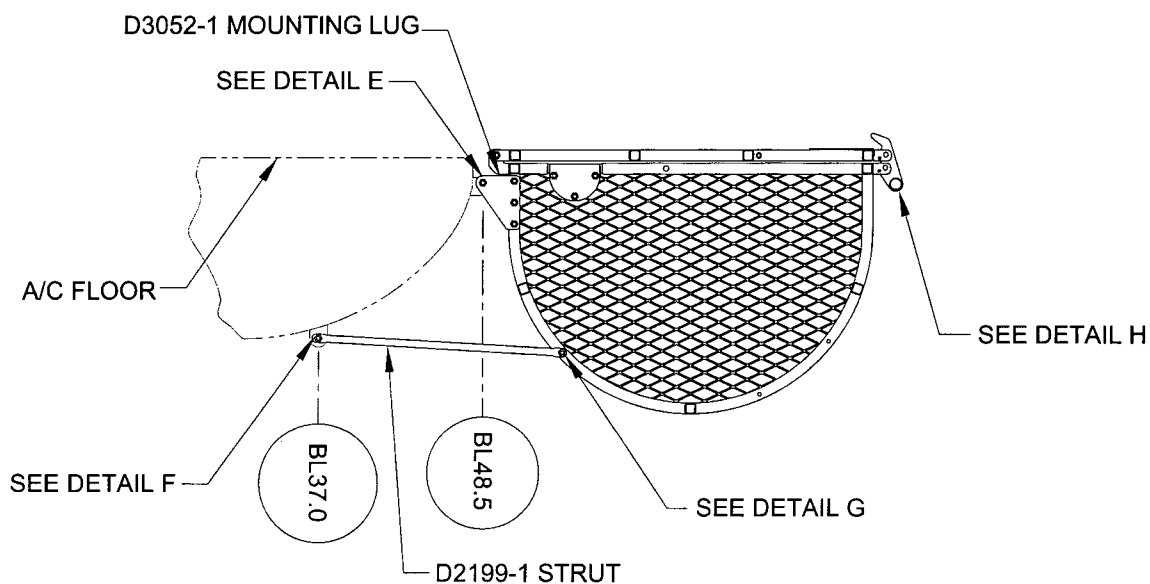


Figure 3b – Section B-B Looking Fwd at STA 129.00
(D205-541-046 Shown; D205-541-045 Opposite)

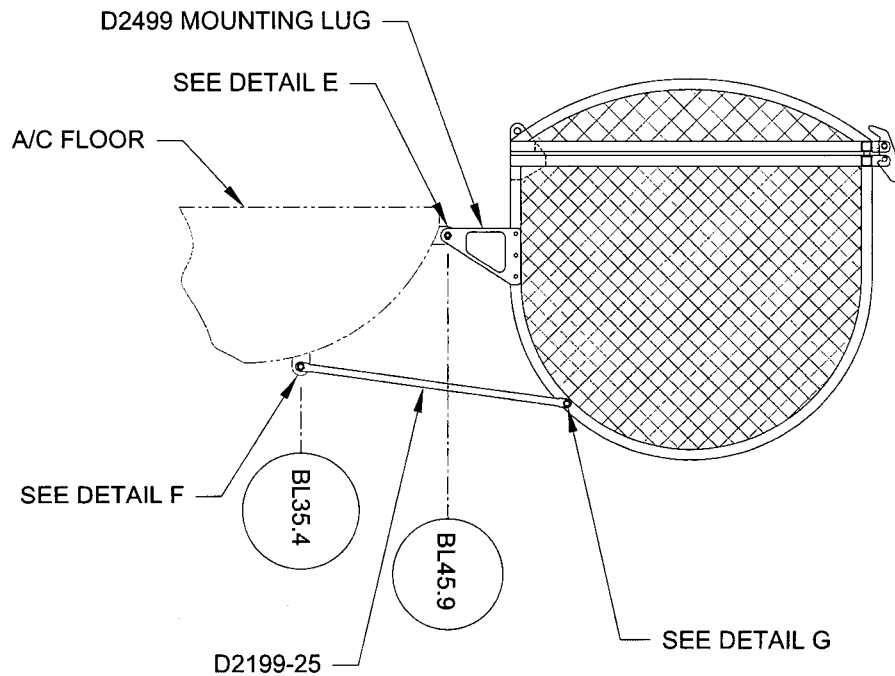


Figure 4a – Section C-C Looking Fwd at STA 155.06

(D205-541-044 Shown; D205-541-043 Opposite)

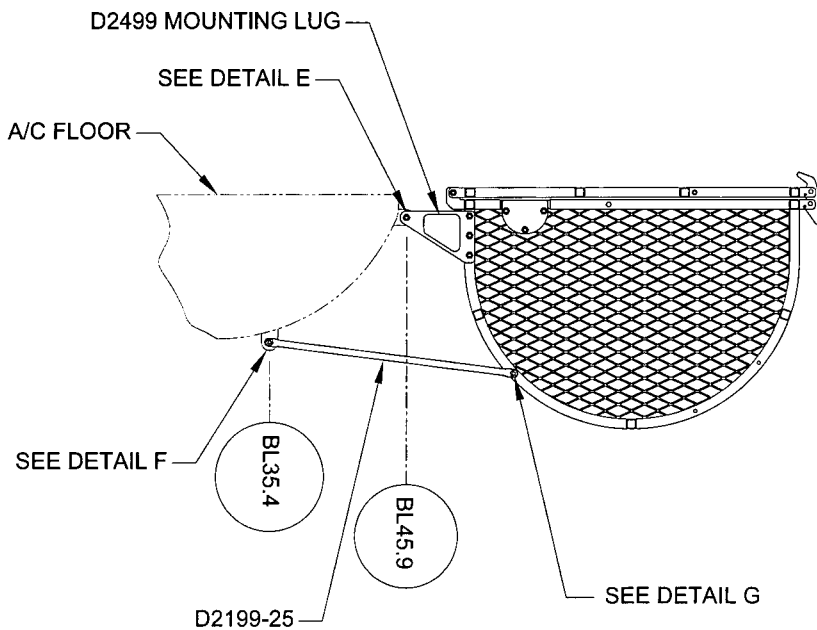


Figure 4b – Section C-C Looking Fwd at STA 155.06

(D205-541-046 Shown; D205-541-045 Opposite)

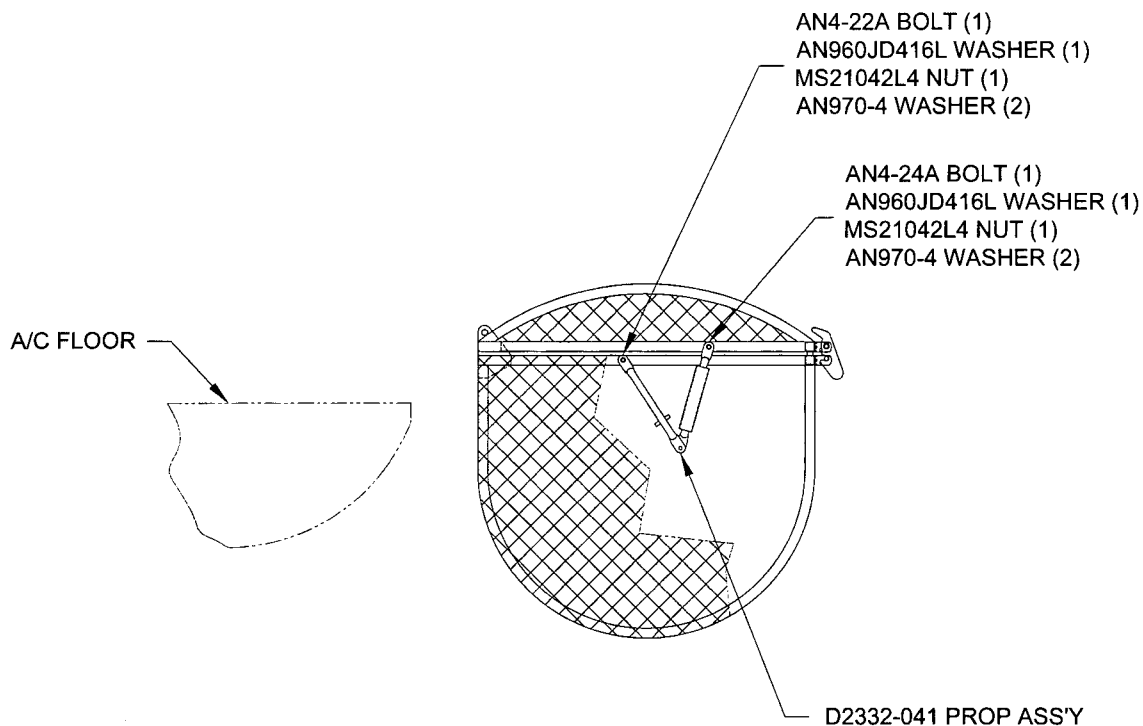


Figure 5a – Section D-D Looking Fwd at STA 180.08
(D205-541-044 Shown; D205-541-043 Opposite)

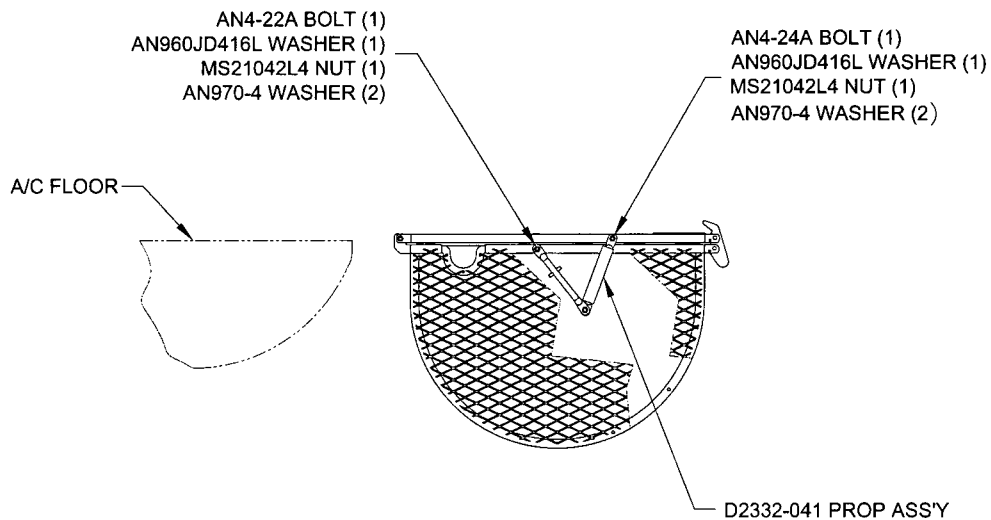


Figure 5b – Section D-D Looking Fwd at STA 180.08
(D205-541-046 Shown; D205-541-045 Opposite)

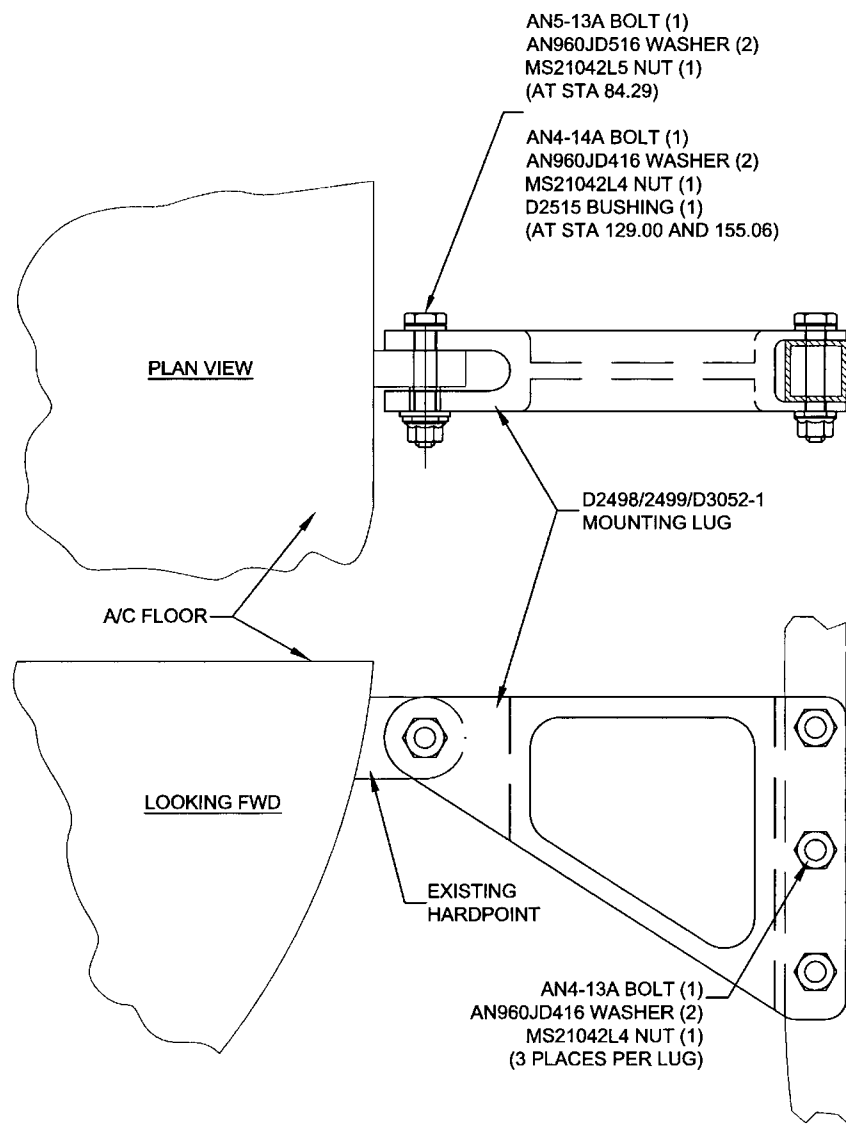


Figure 6 – Detail 'E' Mounting Lug Installation

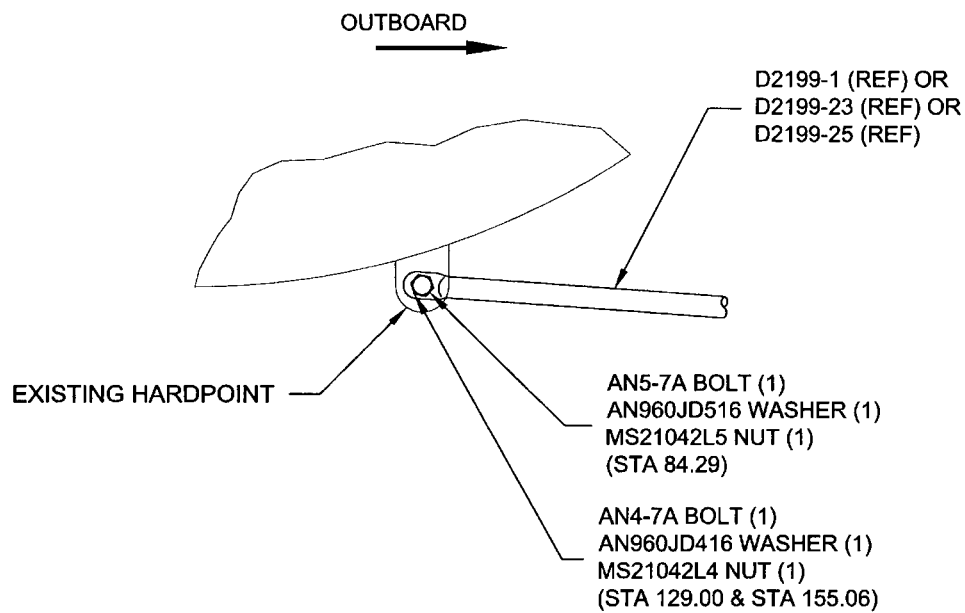


Figure 7 – Detail 'F' Strut to Hardpoint Attachment
(D205-541-044 & D205-541-046 Shown; D205-541-043 & D205-541-045 Opposite)

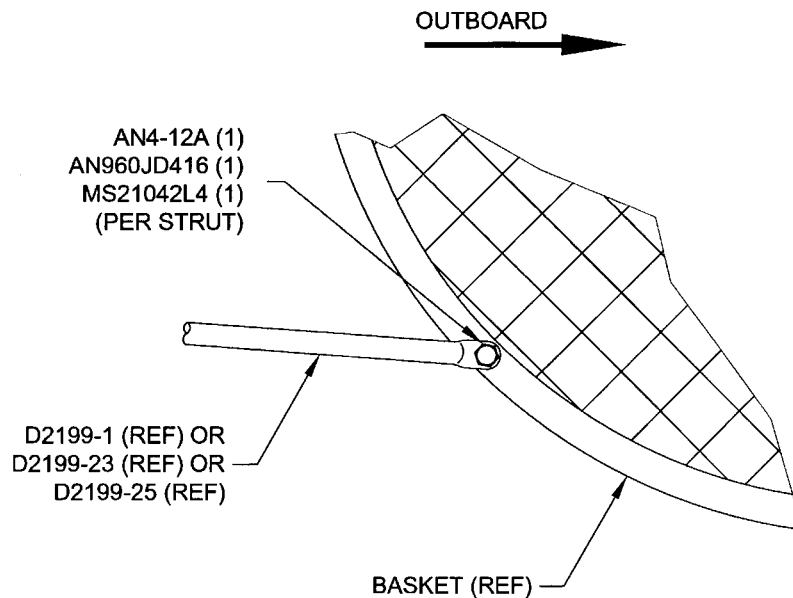


Figure 8 – Detail 'G' Strut to Basket Attachment
(D205-541-044 & D205-541-046 Shown; D205-541-043 & D205-541-045 Opposite)

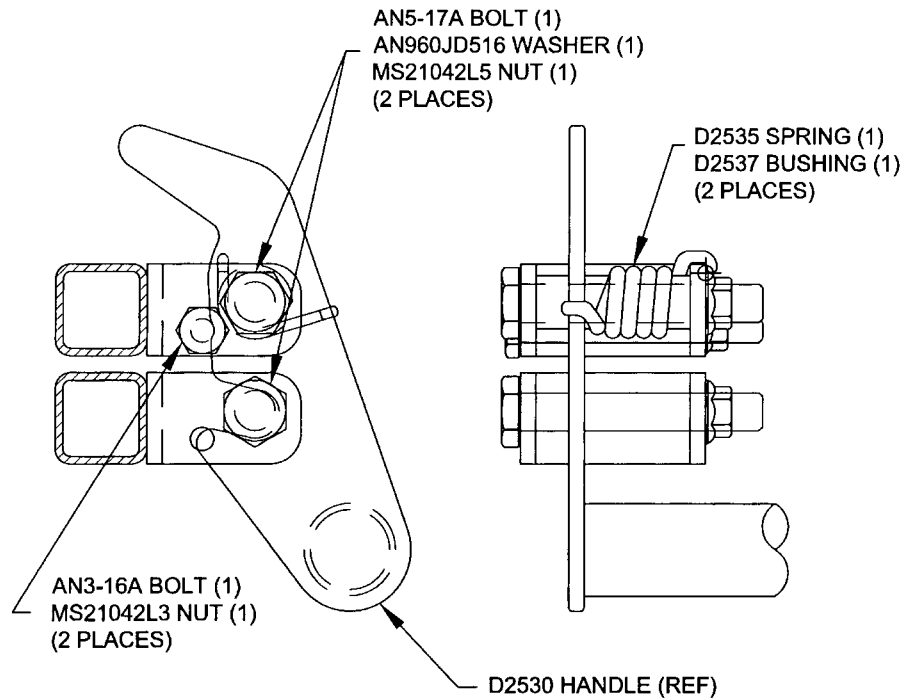


Figure 9 – Detail 'H' Handle Assembly

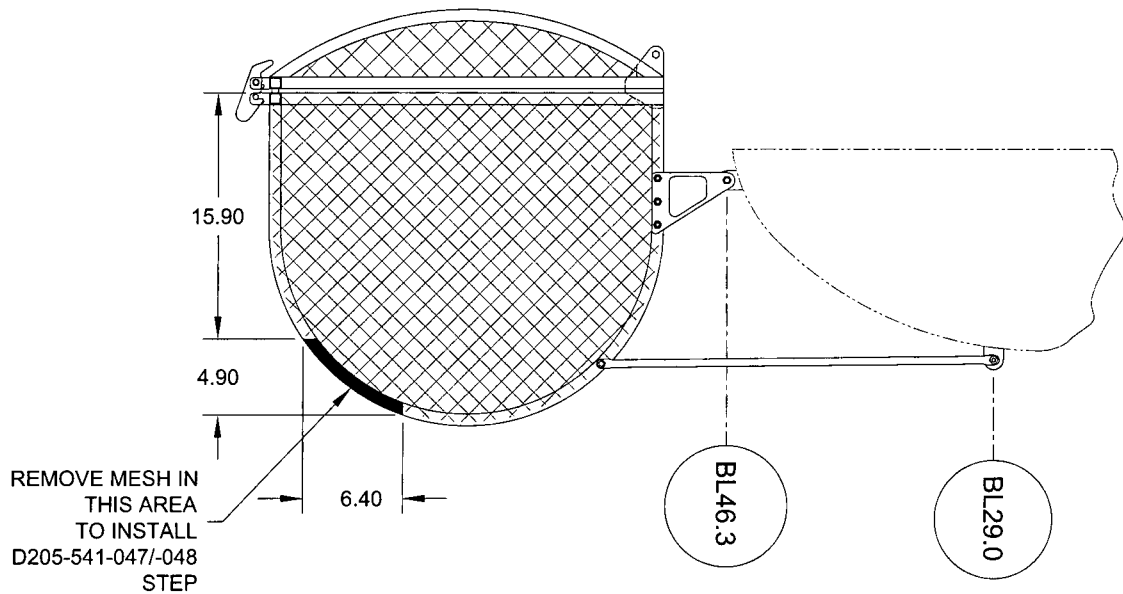


Figure 10 – Mesh Removal Looking Aft at STA 84.00
(D205-541-044 Shown; D205-541-043 Opposite)